: ASPIRATOR ASSEMBLY

: D2410

: N/A

: B

D2410 REV. B

Date

Tuesday, 11/29/2005 5:05:19 PM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material **Due Date**

Drawing Number

Project Number

Drawing Revision

Customer Job Number : CU-DAR001 Dart Helicopters Services

Type

: 25014

S.O. No. : NIA

Estimate Number

: 10480

P.O. Number

This Issue Prsht Rev. : NIA : 11/29/2005

: NC

First Issue : 11/29/2005

Previous Run

Written By

Checked & Approved By

Comment

: Est:C 03.04.14 Reformat; Incorporated D2292;

: SMALL /MED FAB

D2375-3-08-106; D2403 - D2417 KJ/RF

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3

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: Insulation 48'of 3"ID*1/

1.0

D2375308

Comment: Qty.:

0.8333 f(s)/Unit

Insulation 48'of 3"ID*1/ Pick:

Qty

D2403

10.6"

D2375-3-08

Part Number

Description

Total:

Insulation

1810

Outer Skin

2.0

Comment: Qty.:

1.0000 Each(s)/Unit Total:

Description

4.0000 Each(s)

3.3332 f(s)

Outer Skin

Pick:

Qty

Part Number

D2403

Outer Skin

FF 06-10-30

FF 06-10-30

3.0

1 D2404



Comment: Qty.:

1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Perforate Sheet, 0.125 Ho

Pick:

Qty

Part Number

D2404

Description Perforated Sheet

FF 06-10-30 14×2/B25063XI

4.0

1 D2411

Valve support, 5052-H34



Comment: Qty.:

1.0000 Each(s)/Unit Total:

4.0000 Each(s)

Valve support, 5052-H34

Pick: Qty

Part Number

Description

Batch

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User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: ASPIRATOR ASSEMBLY** Job Number: 25014 Part Number: D2410 Job Number: Seq. #: Machine Or Operation: Description: 1 D2411 Valve Mtg Angle 06-10-30 D2412 5.0 3.0692 sf(s) Comment: Qty.: 0.7673 sf(s)/Unit Total: Insulation filter Pick: Qty Part Number Description 06-10-30 110.5si D2412 Insulation Filter 6.0 D2413 Intake Weldment Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Intake Weldment Pick: Qty Part Number Description FF 06-10-30 2 1 D2413 Intake Assembly 7.0 D2414 Comment: Qtv.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) **Outlet Weldment** Pick: Qty Part Number Description 06-10-30 1 D2414 **Outlet Assembly** 8.0 D2416 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Mounting angle, 1x.625x. Pick: Qtv Part Number Description 1 D2416 Mounting Angle 9.0 D2417 Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s) Mounting angle, 1x.625x. Pick: Qty Part Number Description B26908×2/B21844-×1 D2417 **Mounting Angle**

Date:

* Tuesday, 11/29/2005 5:05:19 PM

Dart Aerospace Ltd

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Date: Tuesday, 11/29/2005 5:05:19 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services Drawing Name: ASPIRATOR ASSEMBLY Job Number: 25014 Part Number: D2410 Job Number: Seq. #: Machine Or Operation: Description: 10.0 MS20470AD45 Rivet, Universal Head Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description MS20470AD4-5 Rivet 11.0 MS20600AD4W2 Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s) Rivet Pick: Qty Part Number Description 15 MS20600AD4W2 Rivet 3 06-10-30 (or CR9163-4-2) MS20600AD4W3 12.0 Cherry Rivets Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s) Cherry Rivets Pick: Qty Part Number Description MS20600AD4W3 Rivet 06-10-30 3/0 (or CR9163-4-3) 13.0 MS20600AD4W4 Rivets Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s) Rivets Pick: Qty Part Number Description Batch MS20600AD4W4 Rivet 06-10-30 3 (or CR9163-4-4) 14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 PTO Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2410

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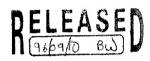
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▼ Tuesday, 11/29/2005 5:05:19 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: ASPIRATOR ASSEMBLY** Job Number: 25014 Part Number: D2410 Job Number: Seq. #: **Machine Or Operation:** Description: 15.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 16.0 POWDER COATING POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3 ****Place masking tape on red anodize tube of flare section and access to interior of both ends.**** 17.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT 18.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 19.0 DOCUMENT CONTROL Comment: DOCUMENT CONTROL 1 Inspection Level 21 U Obel 2-11 Job Completion

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PRE	PARED		DART AERO ACCESSORIES	INC
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B	w	[wa	D2410 SHEET	1 OF 2
DAT	Ε		TITLE	SCALE
Ар	r. 6,	1995	206 ASPIRATOR ASSEMBLY	
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QTY	Part No.	Description					
X	D2410	B206 ASPIRATOR ASSEMBLY					
1	D2375-3-08-106	INSULATION					
1	D2403	OUTER SKIN					
1	D2404	PERFORATED SHEET					
1	D2411	VALVE MOUNTING ANGLE					
1	D2412	INSULATION FILTER					
1	D2413	INTAKE ASSEMBLY					
1	D2414	OUTLET ASSEMBLY					
1	D2416	. MOUNTING ANGLE					
1	D2417	MOUNTING ANGLE					
8	MS 20600 AD 4WZ	QIVET (CR9163-4-2)					
1	MS 20600AD4W3	RIVET / CR 9/63-4-3\					
12	MS 20600 AD 144	RIVET / (R9163-4-4)					
8	MS20470AD4-5	Rivets					

